

Date: Tuesday, 8/21/2007 3:42:45 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 34170	
Estimate Number : 10613	
P.O. Number : <i>N/A</i>	Part Number : D265615
This Issue : 8/21/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2656 REV D
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision : D
Previous Run : 32579	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 9/10/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: D 02.10.25 Re-format KJ	
Est Rev:E Now on Waterjet 06-09-25 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.6431 sf(s)/Unit Total : 12.8625 sf(s)
 1010/1025/A21/6aA SHEET (.040")
 (M1010S20GA)
 Batch: *M104921 HB 07-08-24*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D2656
 Dwg Rev: *D*
 Prog Rev: *D* *HB 07-08-24*

2-Deburr if necessary

(20)
John 07/08/27

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

center
Er 07/08/28 (20)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326
 2-Form joggle as per Dwg D2656 using Jig DT8158
 3-Identify as D2656-15

HB 07/08/28 (20)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/09/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:42:45 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 34170

Part Number: D265615

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ed 07/08/09 (20x)

7.0

POWDER COATING

POWDER COATING



M 104846



(20x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-h 07/09/05

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 07/09/05 (20x)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(20x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FP-14

m-h 07/09/06

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(20x) 07/09/06

Job Completion



U 07-09-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34170
Description: Wearshoe		Part Number:	D2656-15
Inspection Dwg: D2656 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.150	+/-0.010	39.150	*			
35.650	+/-0.010	35.650	*			
33.650	+/-0.010	33.650	*			
30.150	+/-0.010	30.150	*			
24.900	+/-0.010	24.900	*			
19.650	+/-0.010	19.650	*			
14.400	+/-0.010	14.400	*			
9.150	+/-0.010	9.150	*			
5.650	+/-0.010	5.650	*			
2.000	+/-0.010	2.00	*			
1.885	+/-0.010	1.888	*			
0.300	+/-0.010	.300	*			
0.300	+/-0.010	.300	*			
0.040	+/-0.010	.38	*			

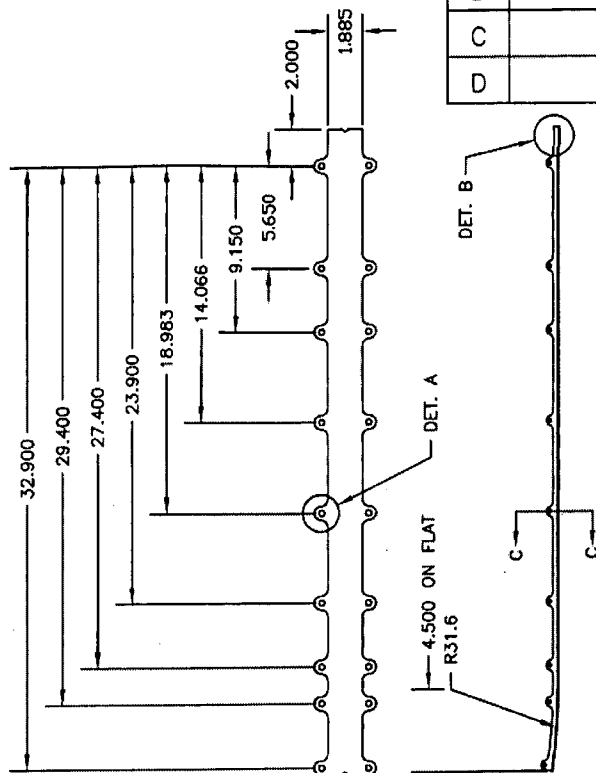
Measured by: RB	Audited by: Er	Prototype Approval:	N/A
Date: 07-08-24	Date: 07/08/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM AK	BE

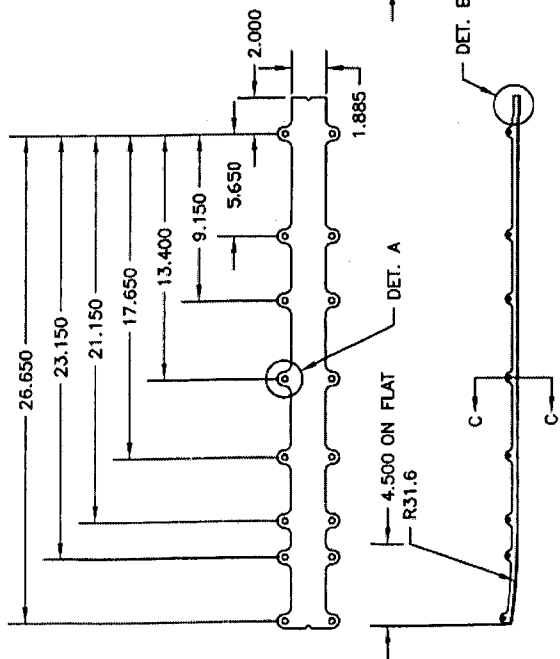


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				D2656	SHEET 1 OF 4
DATE	05.08.17			TITLE	SCALE
				WEARSHOE	1:10
A	97:03:25			NEW ISSUE	
B	97:06:02			CHANGED TABS	
C	97:06:26			R31.6 WAS R19.5	
D	05.08.17			ENLARGE ALL HOLES TO IMPROVE FIT	

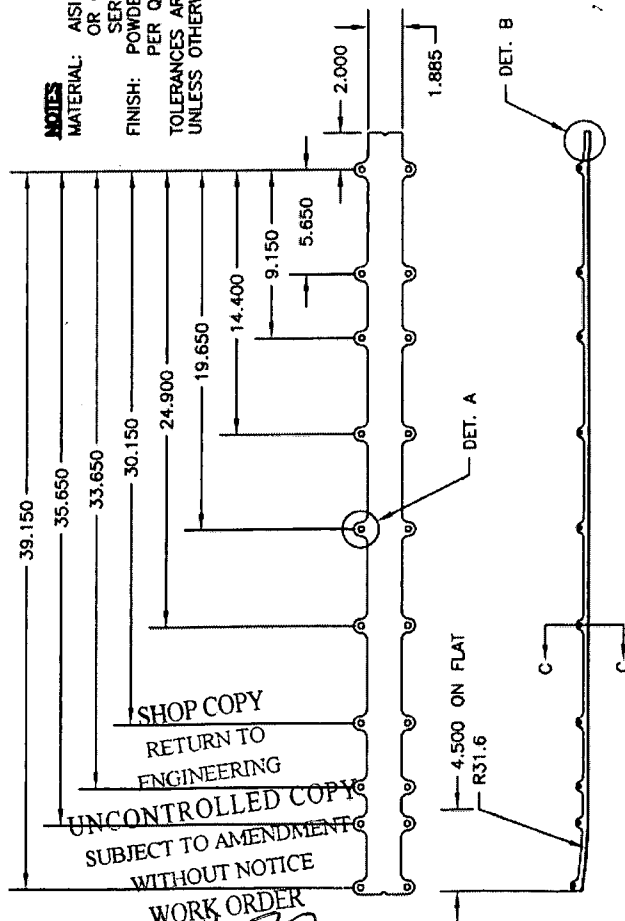
D2656-13



D2656-11



D2656-15



NOTES
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
 OR CSA C40-21, 38W/44W/50W/60W/70W
 SERIES STEEL, 20 GAUGE (0.040 THICK)
 FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
 PER QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018
 UNLESS OTHERWISE NOTED

RELEASED
 05-09-08

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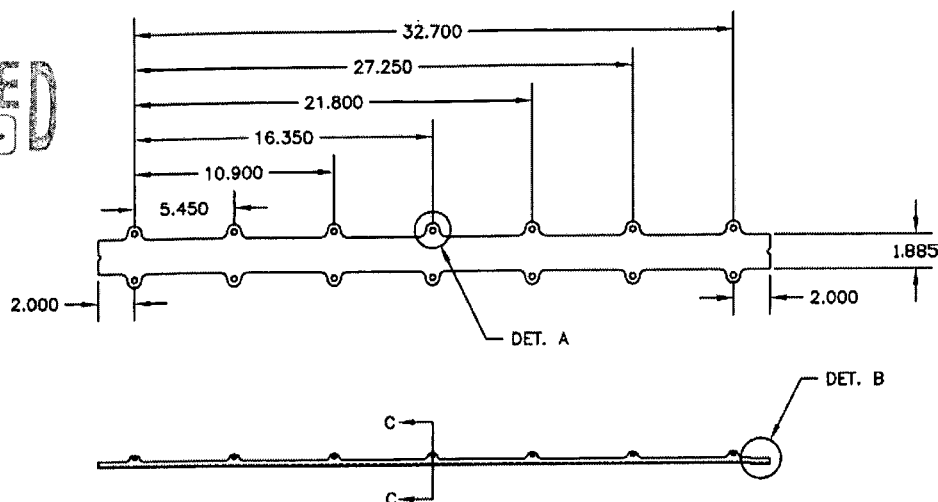
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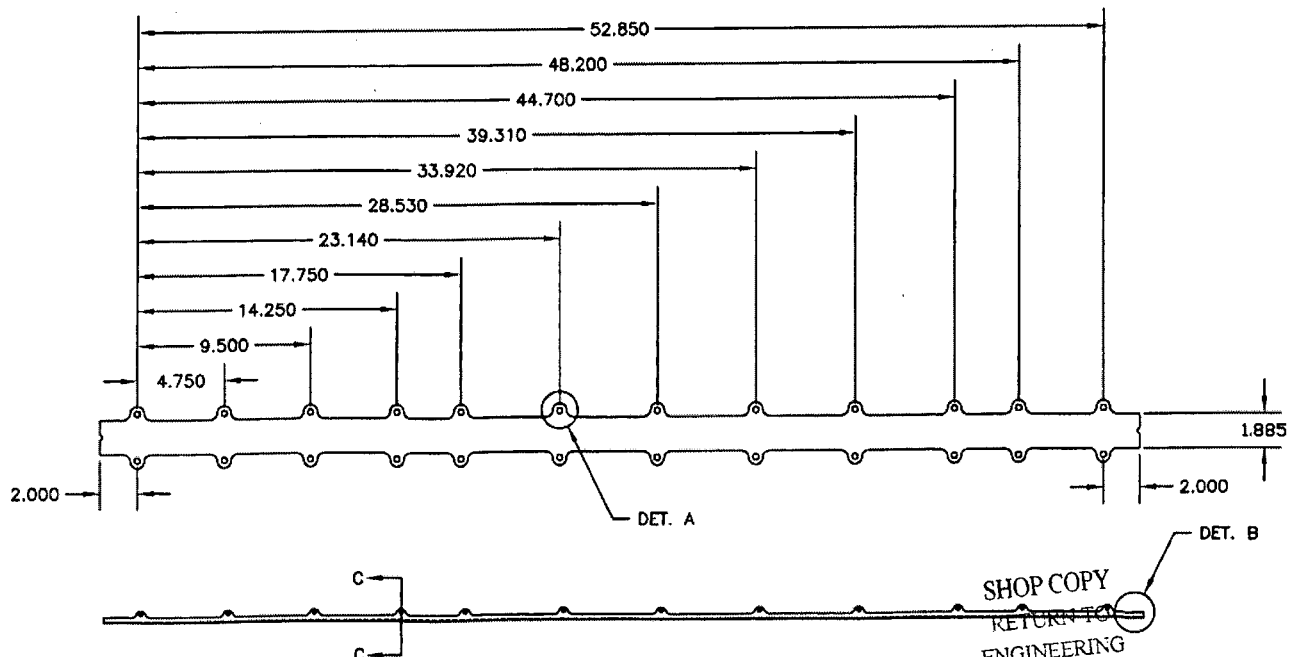
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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DS-07-06 *[Signature]*

D2656-21



D2656-23



NOTES

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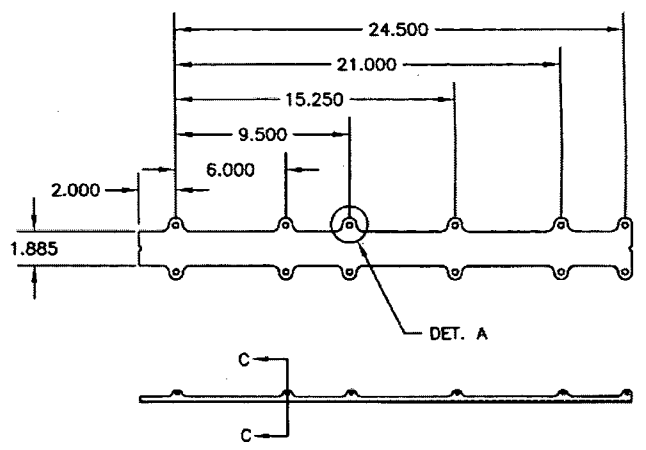
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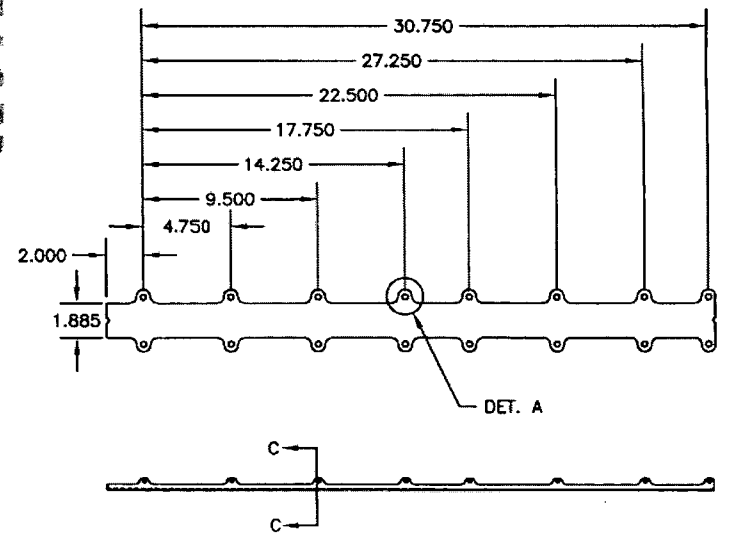


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		TITLE	WEARSHOE	SHEET 3 OF 4
		SCALE	1:10	

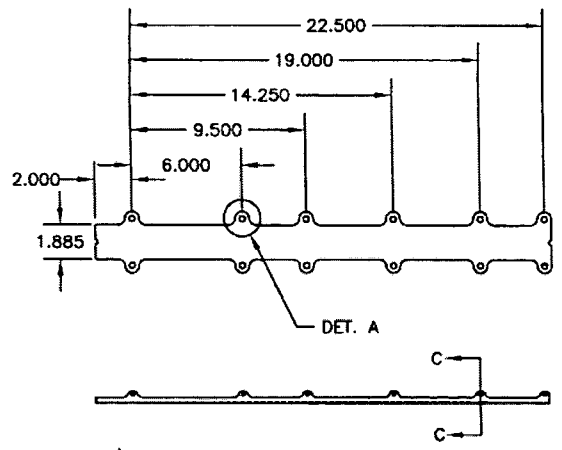
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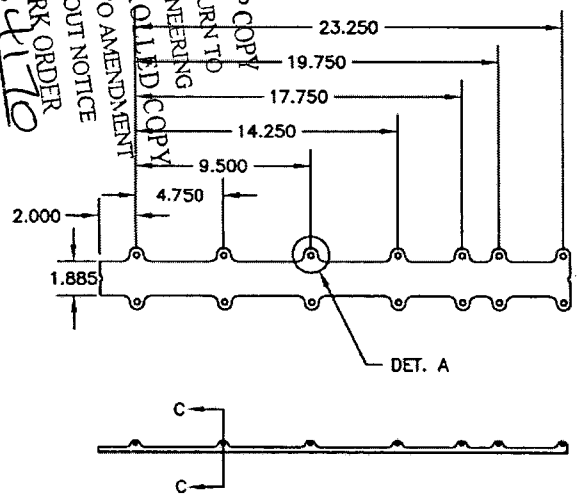
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D2656-31



D2656-35



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NOTES

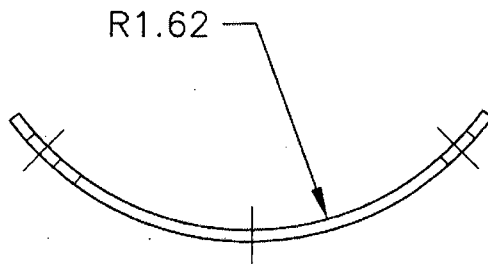
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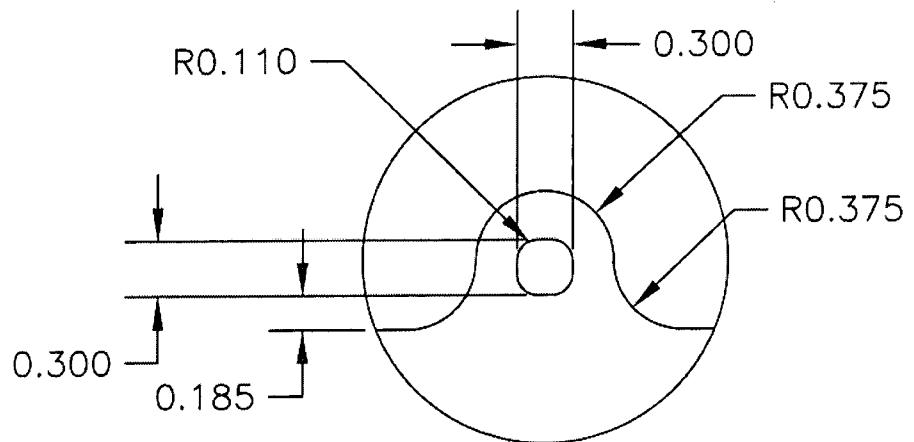
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

SECTION C-C

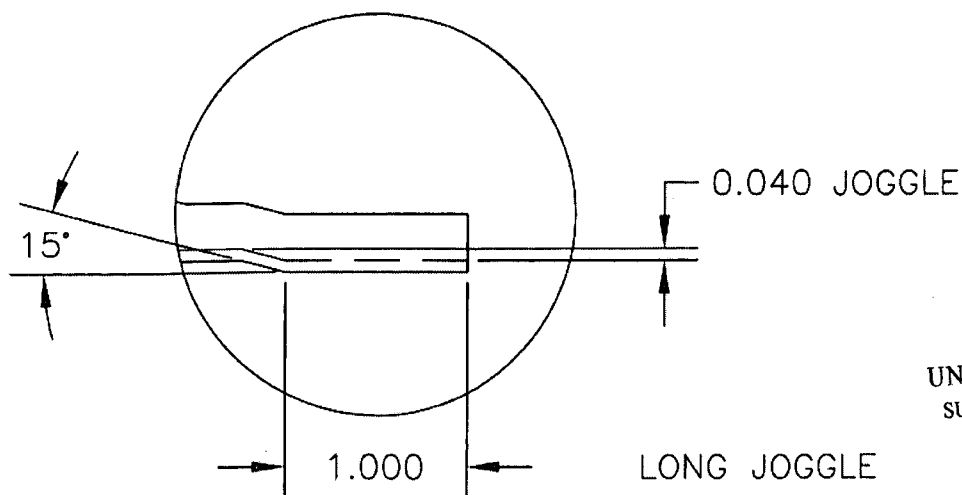


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DETAIL B



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